

Work Order ID 81296

March-12-12 4:41:59 PM

ASAP

81296

Page 1

Item ID: D350-591-214

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Short RH

Start Date: 12/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 26/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MLC

Date: 12/03/13 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3078

A

DSI 9472

A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-214 CHG003

96 5/26/13

MLC 12/04/13

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

12-03-20
12-03-20

6 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Required Date: 26/03/2012 Req'd Qty: 6.00

6

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Reference:

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NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

lpc 12.03.20

120

QC

Memo

0.00

Quality Control

6x

Ø

130

Large Fab

0.00

130

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY
2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078
A/RAluminum Rod *119785*
3-Grind End Plate flush *120169*

ll 12.03.22

6

Ø

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00

140

QC

Memo

0.00

Quality Control

6

Ø

BE 12-03-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150		0.00							
QC	Memo								
Quality Control									
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160		0.00							
HandFinish	Memo								
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
170		0.00							
QC	Memo								
Quality Control									

76
RH

6X of m-12/03/28
RH

6 PL 12-3-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

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Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00

200

Large Fab

Large Fab

Memo

0.00

Large Fab

1- Rivet Leg Assembly as per Dwg D3078.

2-Bevel Aft end for welding

3-Inspect for foreign object as per QSI 024

4-Weld Aft End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod 119785

5-Grind End Plate flush

210

QC10- Inspect visual per QSI004- ground welds

0.00

210

QC

Memo

0.00

Quality Control

fl

Ac 12.04.11

Ac 12.11

8/12/12

*X6
R4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 5

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Cust Item ID:

Required Date: 26/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220 QC5- Inspect part completeness to step on W/O

0.00

220

QC

Memo

0.00

Quality Control

Scrlg/12

(x6)

RH

230 Chemical Conversion Coat per QSI005 4.1

0.00

230

HandFinish

Memo

0.00

Hand Finishing

6 φ 12/4/12

240 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

240

Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:30
OVEN TEMPERATURE: 320 °F
FINISH TIME: 12:00

6x ✓ M-L 12/04/13

M120222

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 7

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Item ID: D350-591-214 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step, Short RH
 Start Date: 12/03/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 26/03/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC4- 100% Inspect kits for completeness	0.00							
280									
QC	Memo	0.00		Sizelick		(x6)			
Quality Control						RH			
290	Packaging	0.00							
290									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-591-214								
	Location: _____								
	PPP Rev: _____								
300	QC21- Final Inspection - Work Order Release	0.00							
300									
QC	Memo	0.00							
Quality Control									

6x 12-04-19

MCT 12/04/20

12-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 1

March-12-12 4:42:02 PM

Work Order ID: 81296

81296

Parent Item: D350-591-214

D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:B05.10.14Modified step 10KJ/EC

IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM

IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D

10.11.15 update qty on AN4-11A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured No

110

Each

78.7300

0.5

3

D2622-120C

Step Extrusion

**

12.03.20

Location

Loc Qty

Loc Code

HALL

16.37

46910

2

64409

6

66970

7.7

68293

0.25

72131

0.42

WA013

62.36

75781

2.4

77612

59.96

D3063-1

Manufactured No

130

Each

65.0000

1

D3063-1

Support

**

12.03.22

Location

Loc Qty

Loc Code

WA016

65

66182

5

71886

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 81296

81296

Parent Item: D350-591-214

D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 6.00

Required Qty: 6.00

D3067-1

Manufactured No

130

Each

178.0000

1

6

D3067-1

End Plate

**

12.03.22

Location

Loc Qty

Loc Code

WA

152

78608

92

80881

60

WA016

26

67582

2

68214

1

79607

23

D3066-1

Manufactured No

200

Each

66.0000

2

12

D3066-1

Spacer

**

B81968 (x6) Ae 12.04.11

Location

Loc Qty

Loc Code

WA

66

78605

66

(x6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 81296

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Parent Item: D350-591-214

D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 6.00

Required Qty: 6.00

MS20600-AD4W4

Purchased

No

200

Each

2,478.000

16

96

MS20600-AD4W4

Rivets

**

M121011 (x95) Az 12.04.11

M121390 (x1)

Location

Loc Qty

Loc Code

ST321

2473

116188

59

117364

253

117601

200

117885

195

118840

1089

119860

30

119883

155

120308

72

120769

420

WA018

5

116712

5

D3065-041

Manufactured

No

200

Each

44.0000

1

6

D3065-041

Step Leg Assembly Hi

**

Az 12.03.29

Location

Loc Qty

Loc Code

WA

44

66149

0

78799

40

79336

1

79419

3

(x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 81296

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Parent Item: D350-591-214

D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 6.00

Required Qty: 6.00

D3067-1 Manufactured No

200 Each

178.0000

1

6

D3067-1

End Plate

**

12-04-18

Location

Loc Qty

Loc Code

WA

152

78608

92

80881

60

WA016

26

67582

2

68214

1

79607

23

AN4-16A

Purchased No

270

Each

122.0000

4

24

AN4-16A

Bolt

**

JB SP

Location

Loc Qty

Loc Code

ST358

122

119980

75

120498

47

D2732

Manufactured No

270

f

197.3353

1

6

D2732

Rubber Extrusion

**

#

JB SP 12/04/18

Location

Loc Qty

Loc Code

ST410

197.335299

70987

197.335299

70987

Cut 3.00" long, qty 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-591-214

D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 6.00

Required Qty: 6.00

AN3-35A Purchased No

270 Each

147.0000

2

12

**

AN3-35A

Bolt

Location

Loc Qty

Loc Code

ST353

147

120187

47

120644

50

120717

50

120187

AN4-11A Purchased No

270 Each

246.0000

2

12

**

AN4-11A

Bolt

Location

Loc Qty

Loc Code

ST356

246

117872

46

118706

100

120731

100

6x117872

6x118706

AN960JD416 NAS1149D0463J Purchased No

270 Each

14.0000

12

72

**

AN960JD416

Washer

Location

Loc Qty

Loc Code

ST351

14

116289

14

D2230-3 Manufactured No

270 Each

187.0000

1

12

**

D2230-3

Lug

Location

Loc Qty

Loc Code

ST480

187

53881

4

70973

1

80009

182

B81558

12-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 6.00

Required Qty: 6.00

D2856-400

Manufactured No

270 f

202.0445 0.6 3.6 ✓

D2856-400

Abrasion Strip

**

JB

Location

Loc Qty

Loc Code

ST409

202.0445

63735

0.6696

68076

0.3149

71164

8.46

79551

192.6

79551

cut 7.20" long, qty 1

MS21042L3

Purchased No

270 Each

3,226.000 2 12 ✓

MS21042L3

Nut

**

121255 JB

Location

Loc Qty

Loc Code

ST300

3226

117441

16

117885

32

118451

5

118927

3

119017

2990

119075

180

119017

AN4-13A

Purchased No

270 Each

1,367.000 4 24 ✓

AN4-13A

Bolt

**

JB 12/04/18

Location

Loc Qty

Loc Code

ST357

1367

119449

59

120187

408

120422

500

120770

400

120422

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D350-591-214

D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 6.00

Required Qty: 6.00

D2230-1 Manufactured No

270 Each

196.0000 2 12 ✓

D2230-1

**

80008 JB [initials]

S Lug
to

Location

Loc Qty

Loc Code

ST 187

78596 187

ST480 9

67826 6

70974 3

MS21042L4 Purchased No

270 Each

3,831.000 6 36 ✓

MS21042L4

**

JB [initials]

S Nut
to

Location

Loc Qty

Loc Code

ST300 3831

117441 51

117601 157

118451 133

119017 200

119075 3290

AN960ID10 * NAS1149D0363J Purchased No

270 Each

0.0000 4 24 ✓

AN960.ID10

**

121243 JB [initials] 12/04/18

S Washer

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:


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




Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
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	X			D350-591-214	Heli-Access-Step ™, Short Step – High Skid, RH
		X		D350-591-215	Heli-Access-Step ™, Short Step – Low Skid, LH
			X	D350-591-216	Heli-Access-Step ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

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NO. 81296 MCT
12/03/13

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		DSI 9472	SHEET 1 OF 2
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

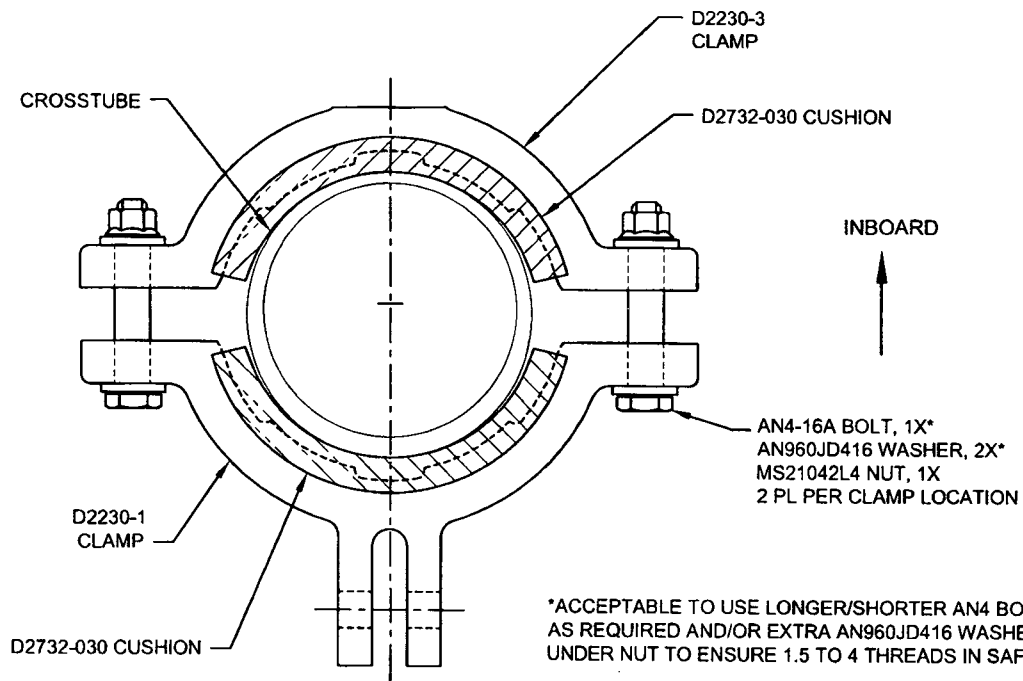


FIGURE 1: CLAMP DETAIL
OPTIONAL CLAMP CONFIGURATION

81296

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	• REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.01.20 *#*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

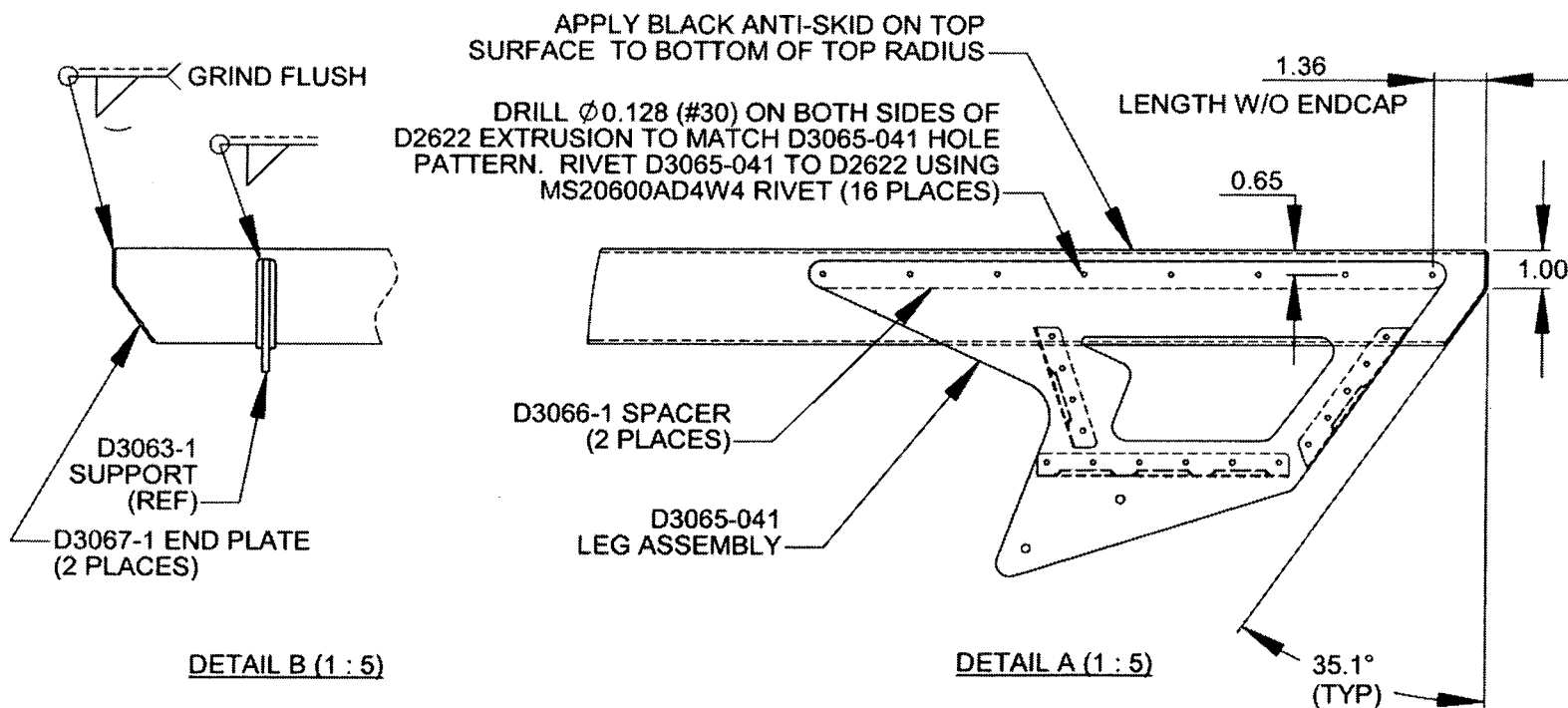
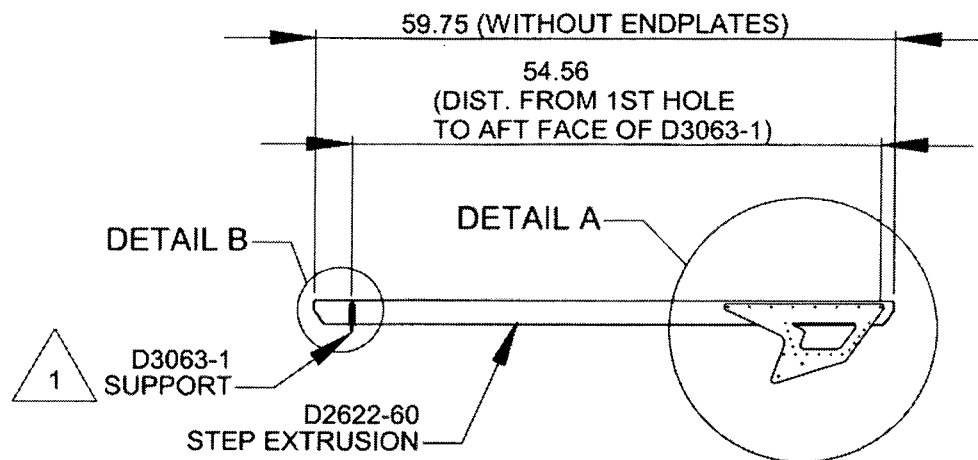


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02.09.2011

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DATE	02.09.11	DRAWING NO. D3078
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		SHEET 2 OF 2
		SCALE 1:20
		TITLE STEP ASSEMBLY, HI SHORT



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

D350-591
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

REFERENCE ONLY

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		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
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BRANCH
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

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.08.05

CERT. NO.: SH92-6

ISSUE NO.: 11

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DESIGN		DART AEROSPACE LTD	
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MFG. APPR.	N/A	DSI 9472	SHEET 1 OF 2
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